

Date: Monday, 5/1/2006 3:57:53 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LID PRO ARM ASSEMBLY (SHORT)
 Job Number : 26880
 Estimate Number : 10258
 P.O. Number : N/A Part Number : D2332041
 This Issue : 5/1/2006 S.O. No. : N/A Drawing Number : D2332 REV C1
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL / MED FAB Drawing Revision : C1
 Previous Run : 25136 Material : N/A
 Due Date : 5/15/2006 Qty: 40 Um: 20 Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]* 06.05.02
 Comment : Est: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/ RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR1000W049 304 RD Tube 1.0" x .049W



Comment: Qty.: 0.4368 f(s)/Unit Total : 8.7360 f(s)
 Material: 1.000" OD x 0.049" wall SS Tube (Seamless)

Batch

M 19448

M.F. 06-05-16

2.0 M304R250 1/4" 304 SS Roundbar



Comment: Qty.: 0.1092 f(s)/Unit Total : 2.1840 f(s)
 Material: Ø0.250" 304SS Rod
 Batch *[Signature]* M 17931

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar

2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin

3-Deburr

M.F. 06-05-15 (10)
 M.F. 06-05-13

4.0 M304TR0500W035 304 RD Tube .500 x .035W



Comment: Qty.: 1.2080 f(s)/Unit Total : 24.1600 f(s)
 304 RD Tube .500 x .035W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012
(Note: Make (2) D2332-11 Prop Arms per assembly.)

M 100928 x 29 FT 06.05.15
M 19488 x 51 FT 06.05.15

40

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly)

M.F. 06.05.23 40

2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)

M 06/05/25 40

A/R SS Rod Batch: M 100372

7.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06-05-29 40

8.0

AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number
1 AN4-4A

Description
Bolt

Batch
M17492 (7)
M19471 (33)

9.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number
3 AN960JD416L

Description
Washer

Batch
M100857 (8)
M101024 (82) 88

M3154 (24)

40

10.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number
1 MS21042L4

Description
Nut (or -4)

Batch
M19085

H.M 06/06/07

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Assemble as per Dwg D2332

H.M 06/06/07

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J 06-06-08

40

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST169

AR 06/06/09

40

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/06/09

40

Job Completion



U 06/06/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

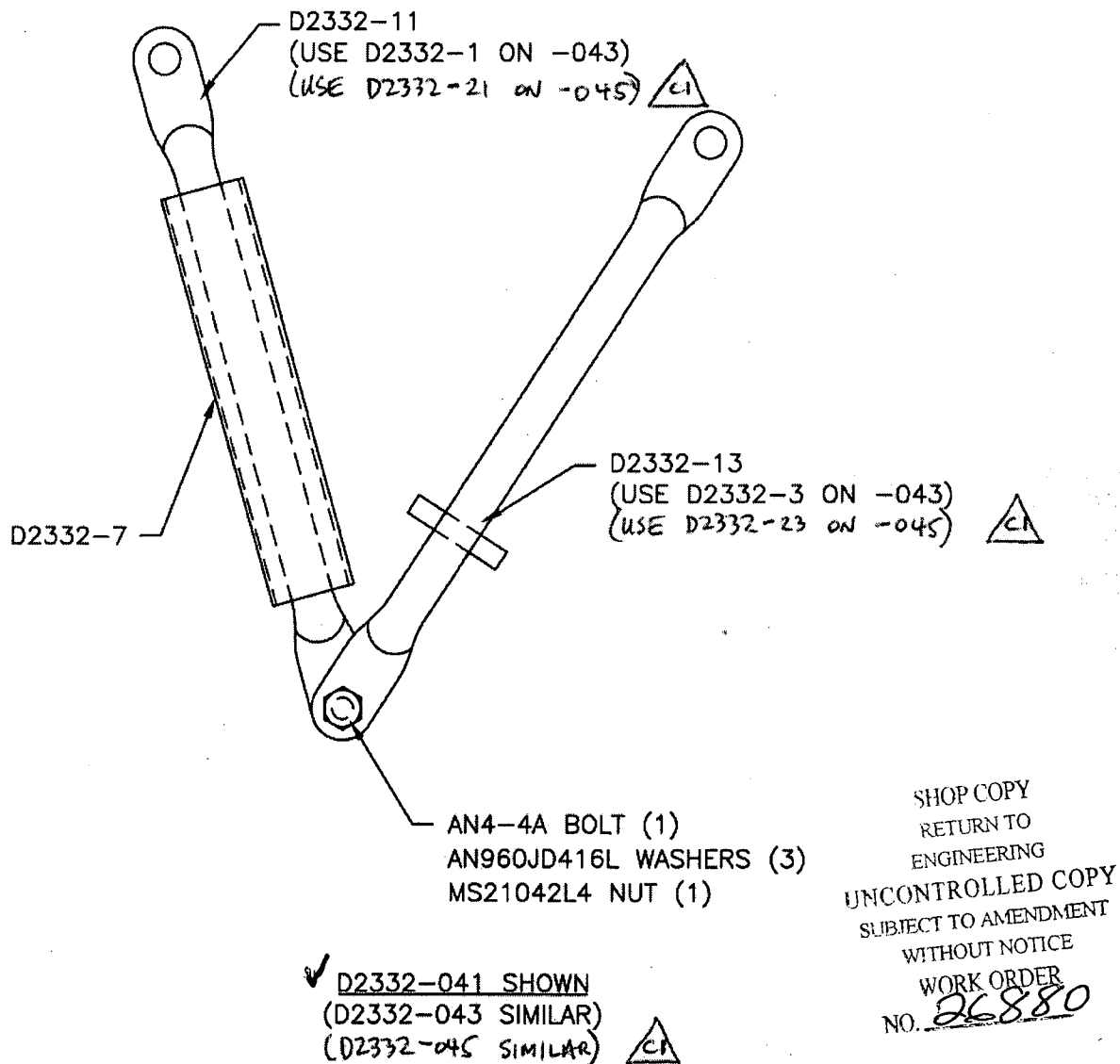
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04 

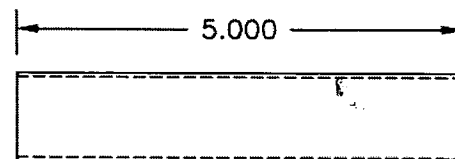
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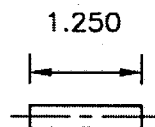
DART



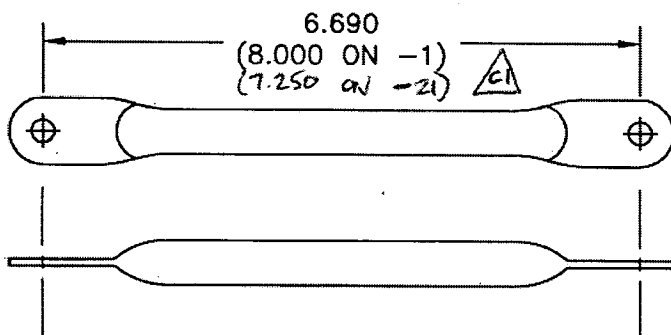
DESIGN	DRAWN BY	DART AEROSPACE LTD
#	#	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
#	#	D2332
DATE	TITLE	REV. C
03.07.03	LID PROP ASSEMBLY	SHEET 2 OF 2
		SCALE
		1:2



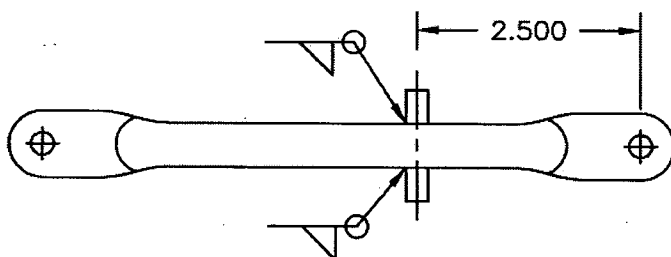
D2332-7 LOCKING COLLAR



D2332-5 STOP PIN



D2332-11 PROP
(D2332-1 SIMILAR)



DRILL 1/4 HOLE FOR D2332-5

D2332-13
M/F D2332-11 & D2332-5

D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
03.07.04

NO. 26880

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER